

**Work Order ID 59141**

Wednesday, May 26, 2010 3:10:56 PM



Page 1

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 5/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:



Date: 105-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3538

Rev A

100



BAND SAW

Bandsaw

Memo

0.00

SF 10/06/03

12 ✓

Jeaspa Bandsaw

Cut blanks 1.500" long

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

SF 10/06/03

12 1

HAAS CNC vertical machine #1

1-Machine as per Folio FA651 and Dwg D3538-2-Deburr

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

AM 10/06/05

12 1

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3S381 PAR #: Fault Category: Machinery NCR: Yes No DQA: Date: 10/06/10  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: HJ Date: 10/06/10

NCR: 59141		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/04	110	One blank pop out of the rise on roughing operation  R.C. cutter have damage before machining and no new one available IN the closet. on order.  R.C. process.		Same Batch # 110001 Replace.	SP 10/06/04	OK 10/06/05	HJ 10/06/04	HJ 10/06/04

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

B.A 10/06/06

12 0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=7 m. l w/06/07

12X

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M114841

0.00

2) 94 10/06/08

12 0

Memo

0.00

START TIME: 8:00 AM OVEN TEMPERATURE:  
FINISH TIME: 3:30 PM 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 59141**

Wednesday, May 26, 2010 3:10:56 PM



Page 3

Item ID: D3538-1

Accept



Setup

Start



Revision ID:

Item Name: Hinge Bracket

Stop



Start Date: 5/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

(12)

BL/10-6-8.

QC

Quality Control

170



Identify as per dwg &amp; Stock Location: 69

0.00

12 BB 10/06/09.

Packaging

Packaging

Memo

0.00

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/06/10 JF

MF

10-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, May 26, 2010 3:11:00 PM

Page 1

Work Order ID: 59141



Parent Item: D3538-1



Parent Item Name: Hinge Bracket

Start Date: 5/26/2010

Required Date: 6/4/2010

Comments: IPP Rev:A New Issue 06-10.03 EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	17.3442	0.19	2.4			

6061-T6 Bar 1.25 x 1.25



Location	Loc Qty	Loc Code
MAT03	17.34421053	
106259	7.06921053	
110001	10.275	

2.400      8.8 10/06/04  
+ 1 part scrap.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59144
Description: Hinge Bracket	Part Number:	D3538-1
Inspection Dwg: D3538 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750	✓			
0.375	+/-0.010	.371	✓			
0.241	+/-0.010	.241	✓			
0.830	+/-0.010	.827	✓			
Ø0.172	+0.005/-0.001	.174	✓			
Ø0.400	+0.006/-0.001	.405	✓			
0.031	+/-0.010	.030	✓			
1.31	+/-0.030	1.306	✓			
0.375	+/-0.010	.368	✓			
0.99	+/-0.030	.984	✓			
0.125	+/-0.010	.125	✓			
R0.19	+/-0.030	.190	✓			
0.083	+/-0.010	.085	✓			
93°	+/-0.5°	93°	✓			
0.674	+/-0.010	.670	✓			
R0.38	+/-0.030	.38	✓			
Ø0.172	+0.005/-0.001	.174	✓			

Measured by:	<i>BF</i>	Audited by:	<i>M.A</i>	Prototype Approval:	N/A
Date:	<i>10/08/04</i>	Date:	<i>10/06/06</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM <i>BF</i>	<i>Shy</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

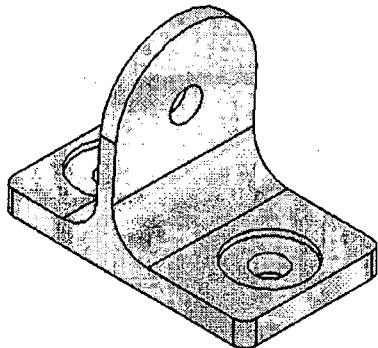
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

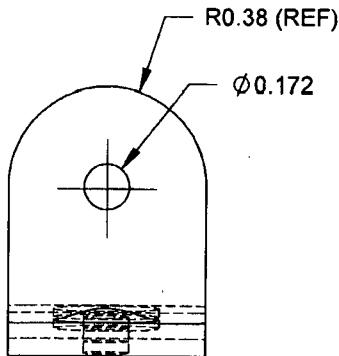
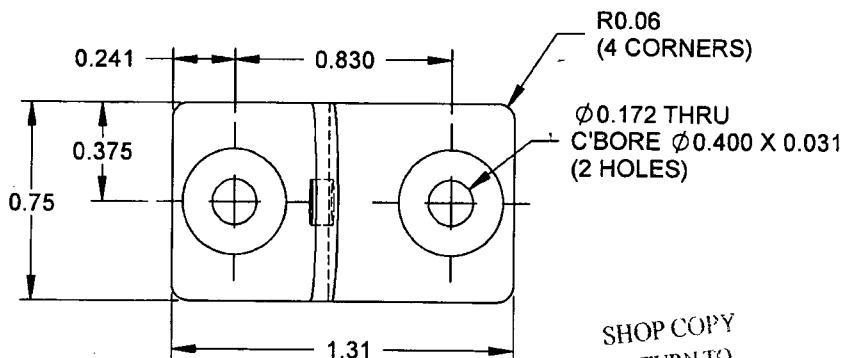
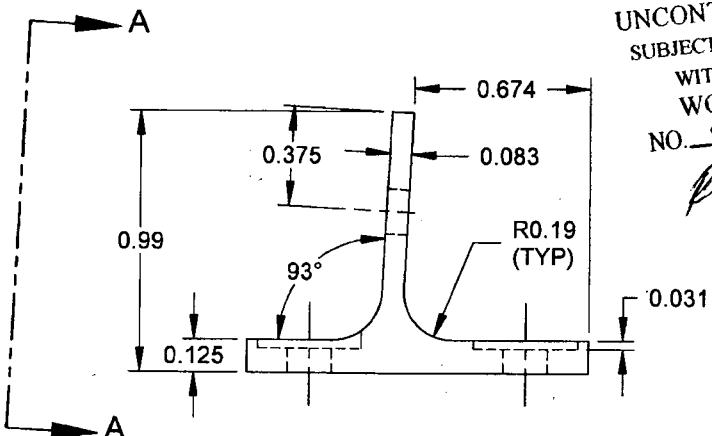
NOTE: Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A	SHEET 1 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1	
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE		



**RELEASED**  
06.10.13 #

**AUXILIARY VIEW A**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *59141*  
*PT 105-20*

**D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

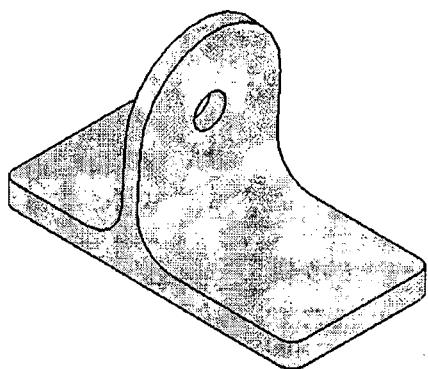
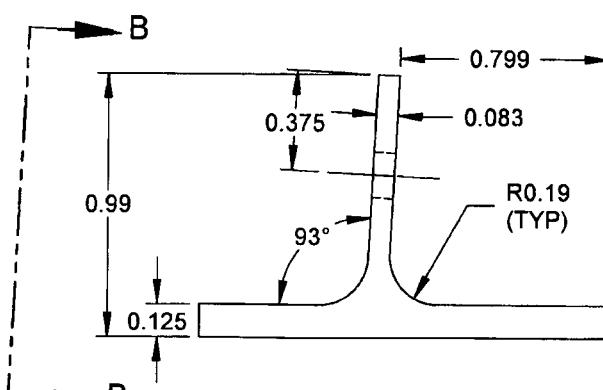
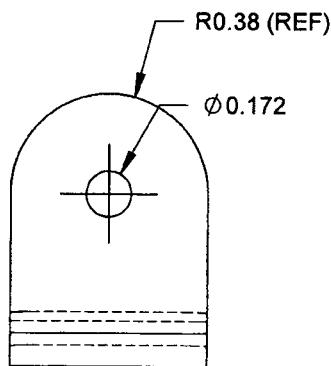
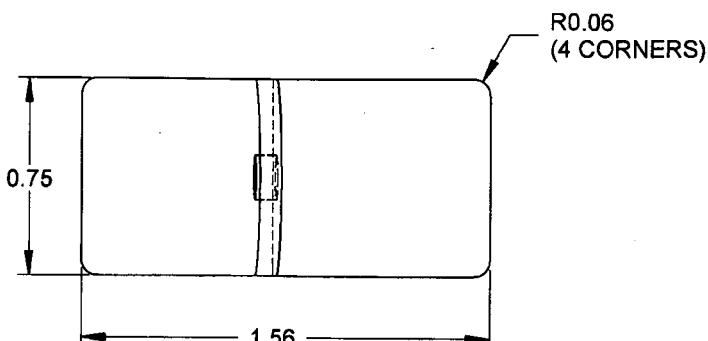
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A	SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET	SCALE 1:1		

**RELEASED**  
06.10.13*46591W***AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries